

# Process Sheet

Form: rprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 5/25/2007 12:49:28 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 32674

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA113

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141.

*RF 07/07/06*

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

*RF 07/07/06*

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*RF 07/07/09* (11)

8.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Remove sand and plugs

2-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

*RF 07/07/09* (11)

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Polish entire outside surface of crosstube

*JD 7-7-12*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*[Signature]*

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*JD 7-7-12*

W/O:		WORK ORDER CHANGES					
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Job Number: 32674

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

EL 7-7-17

13.0

QC15

DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

en 07/07/17

14.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

070718  
207-7-23

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

DP 7-7-23

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

en 07/07/15

17.0

OUTSIDE SERV.10

OUTSIDE SERVICES -LG



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 4266

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

U 070727

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

U 7/8/2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 32674

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

QC6

DIMENSIONAL CHECK



*07-08-02 (1)*



Comment: Inspect for damage & ensure results are as per Dwg D212-664-141

20.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

*RT 07-08-13 (1)*

21.0

QC14

INSPECT SPRAY PAINT



*ml 07 08 14*



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

22.0

D28931

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Eac

Pick:

Qty Part number Description Batch

2 D2893-1 Support *33560*

*ml 07 08 19*

23.0

D3595

Rubber Cush



Comment: Qty.: 0.0840 sf(s)/Unit Total: 0.0840 sf(s)

Rubber Cushion (per sq ft)

.630" X 4.5" 4PCS

Batch: *33542 ml 07 08 19*

24.0

MS2192025

Clamp(per MIL-DTL-878



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-25 Clamp *103897*

*ml 07 08 19*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



Date: Friday, 5/25/2007 12:49:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 32674

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description:

25.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs  
A/R 6398 Magnobond Batch: 104 723 12:00  
Expiry Date: 08-10-01

27 07-08/17

2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

ml 01 08 19

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/20 (X1)

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

PLACARD

Batch: 1320249 SC

29.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M103441 SO

30.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

Batch: M104374 SO

31.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch: M104374 7/8/20 SO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 32674

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M101660

6/8/20 SP

33.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6/07/08/20

34.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

Dec C 7/8/20

SP

35.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/07.08.20

Job Completion



6/07-08-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	<b>32674</b>
<b>Description:</b> Crosstube Assembly (205/212/412 High Fwd)		<b>Part Number:</b>	<b>D212-664-141</b>
<b>Inspection Dwg:</b> D212-664-141 <b>Rev:</b> <del>B</del> C <i>07.01.20</i>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

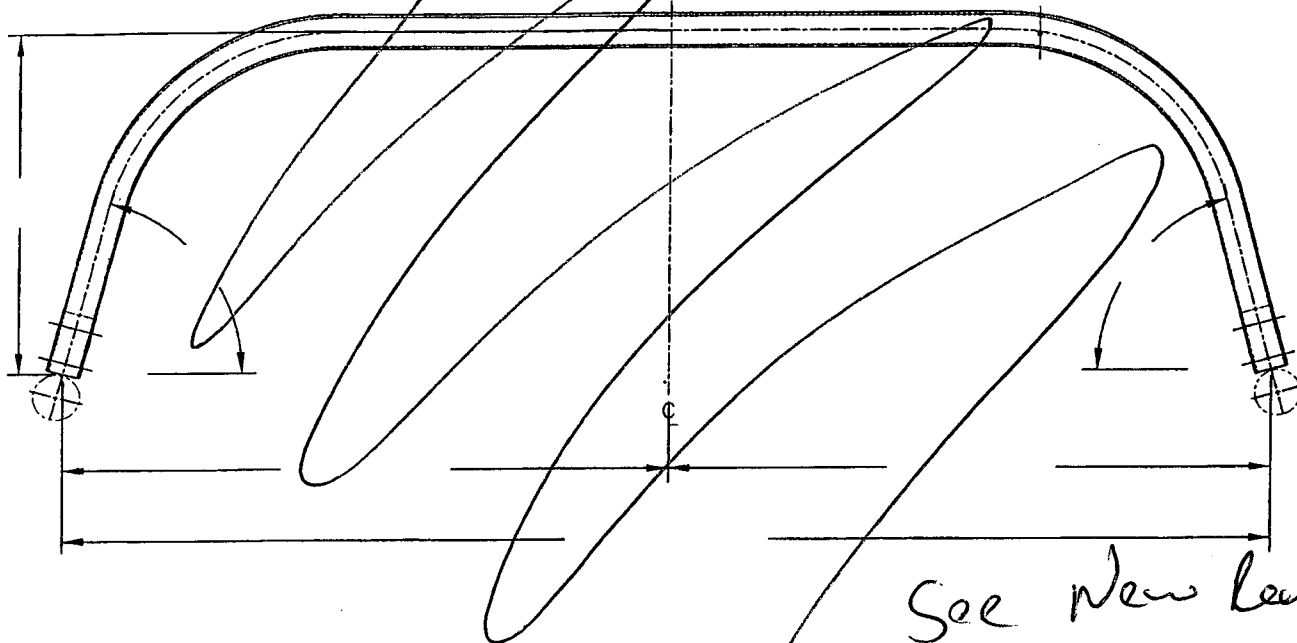
Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	0.200	+/-0.010	.205			
	R0.063	+/-0.010	.063			
	2.740	+0.005/-0.000	2.742			
	5.097	+/-0.030	5.107			
	2.304	+0.005/-0.000	2.306			
	2.340	+0.005/-0.000	2.342			
	2.398	+0.005/-0.000	2.400			
	2.448	+0.005/-0.000	2.450			
	2.498	+0.005/-0.000	2.500			
	2.549	+0.005/-0.000	2.550			
	2.599	+0.005/-0.000	2.601			
	2.671	+0.005/-0.000	2.673			
	2.701	+0.005/-0.000	2.703			
SIDE B	0.200	+/-0.010	.205			
	R0.063	+/-0.010	.063			
	2.740	+0.005/-0.000	2.742			
	5.097	+/-0.030	5.105			
	2.304	+0.005/-0.000	2.306			
	2.340	+0.005/-0.000	2.342			
	2.398	+0.005/-0.000	2.400			
	2.448	+0.005/-0.000	2.450			
	2.498	+0.005/-0.000	2.500			
	2.549	+0.005/-0.000	2.551			
	2.599	+0.005/-0.000	2.601			
	2.671	+0.005/-0.000	2.673			
	2.701	+0.005/-0.000	2.703			
	126.51	+/-0.020	126.51			

<b>Measured by:</b> <i>S.S.</i>	<b>Audited by:</b> <i>Amf</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <i>07/07/05</i>	<b>Date:</b> <i>07/07/09</i>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue (P/O D412-664-101)	KJ/JLM	
B	06.03.15	Tolerance revised for 5.097 per Dwg Rev update	KJ/JLM <i>JA</i>	<i>JA</i>

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	32674
<b>Description:</b> Crosstube High Fwd (205/212/412)		<b>Part Number:</b>	D212-664-101
<b>Inspection Dwg:</b> D212-664-141	<b>Rev:</b> C 1307.05.20	Page 1 of 1	

Required Dimension	Min	Max
Height	26.86	26.98
1/2 Span	53.66	53.78
Angle	49	52
Total Span	107.32	107.56



Comments

QC15 Inspection	
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

**DART**

DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>QP</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

**RELEASED**07.04.24 **[Signature]**

Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128  
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY

THE RETURN TO  
ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

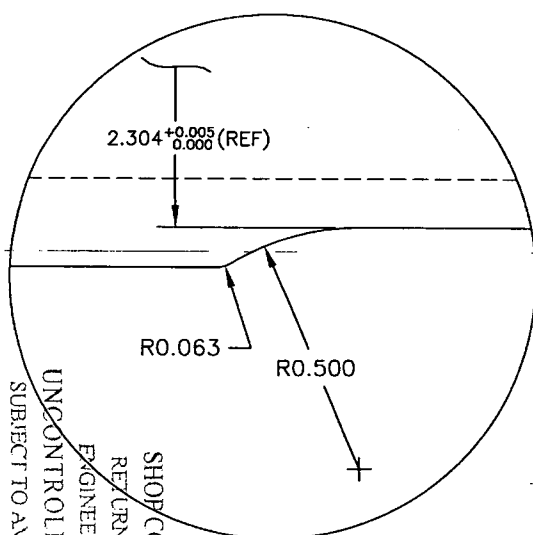
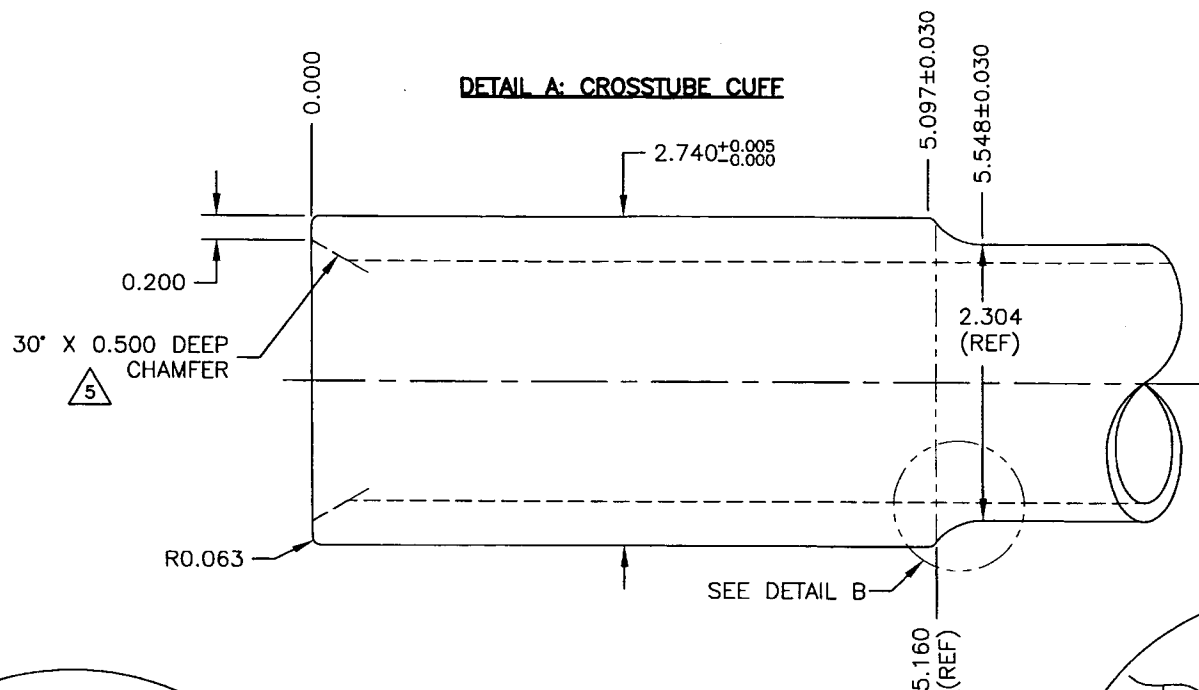
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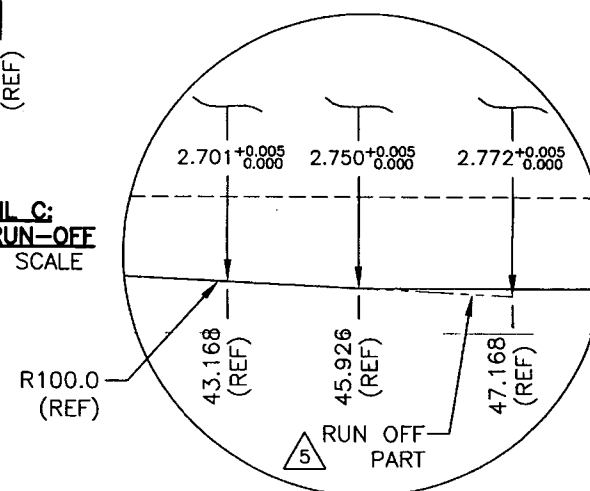




**RELEASED**  
67.04.24 (P)  
PER E.N. 883



**DETAIL C: TAPER RUN-OFF**  
NOT TO SCALE



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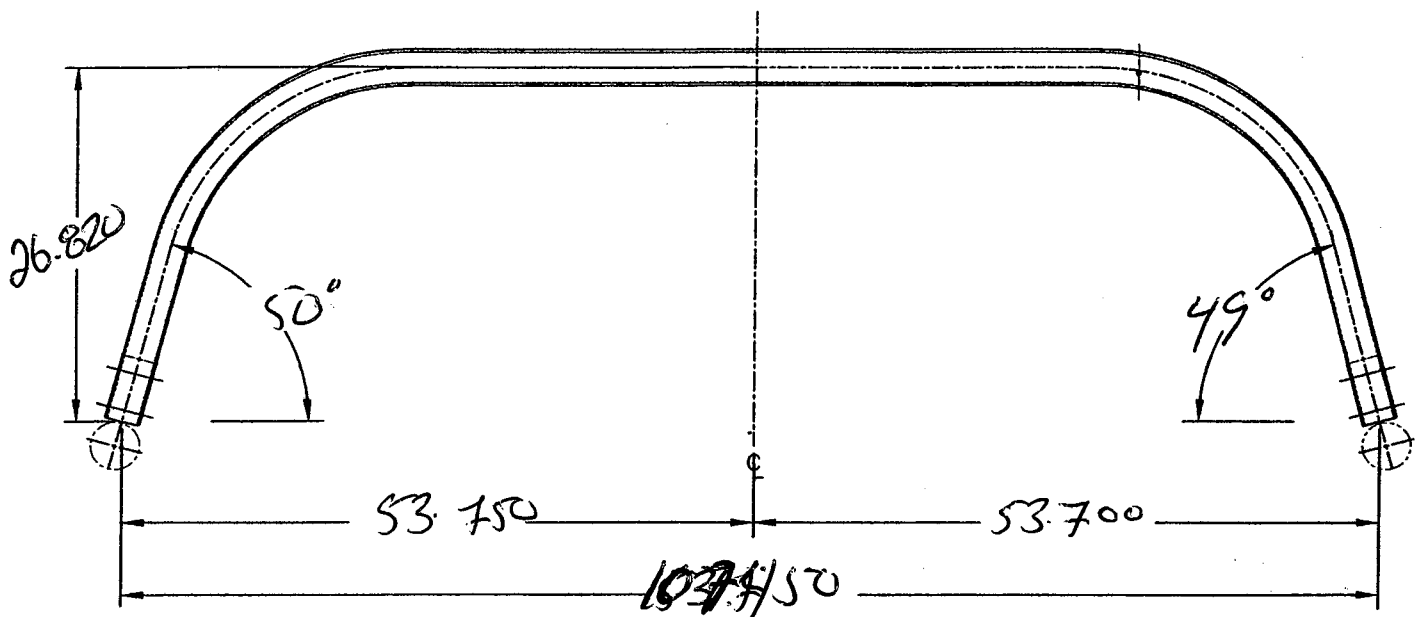
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DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. WARRICKSURY, ONTARIO, CANADA
CHECKED J	APPROVED [Signature]	DRAWING NO. D212-664-141	REV. C SHEET 3 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:1

NO. 32674  
WORK ORDER  
WITHOUT NOTICE  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
ENGINEERING  
REF. TO  
SHOP COPY

DART AEROSPACE LTD		Work Order:	32674
Description: Crosstube High Fwd (205/212/412)		Part Number:	D212-664-101
Inspection Dwg: D212-664-141 Rev: C		Page 1 of 1	

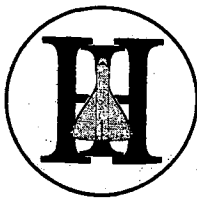
Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	<i>[Signature]</i>
Date	07/07/17

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	



# HeathAir

INTERNATIONAL (1991) INC.

681 Ave. Lepine, Dorval, Québec H9P 1G3  
Tél.: (514) 636-1000 • Fax: (514) 636-0031

W.O. N° 37039

A.M.O. Number: 46/90

## NON-DESTRUCTIVE TESTING REPORT

### AIRCRAFT / COMPONENT INFORMATION

REGISTRATION:

MODEL/TYPE:

SERIAL NUMBER:

TOTAL HR/LDG:

OPERATED BY:

BASED AT:

### INSPECTION REQUIREMENTS

Carry out FPI of six (6) cross tubes (external surface) as per ASTM E-1417-05 and the Dart QSI 038, Section 4.1.1 (on file at client) - parts delivered to HeathAir.

Qty. (1) P/N D212-664-201

S/N B32680

Qty. (2) P/N D212-664-101

S/N's B32673 & B32674

Qty. (3) P/N D412-664-203

S/N's B32228, B32226 & B32227

☐ RADIOGRAPHY

☐ ULTRASONIC

☒ PENETRANT

☐ MAGNETIC PARTICLE

☐ EDDY CURRENT

### INSPECTION REPORT

Fluorescent penetrant inspection was performed in accordance with the above requirements on six (6) cross tubes.

Note: A Level 3 penetrant was substituted for the requested Level 2 (3 is more sensitive)  
Ardrox 970P25E Batch #04B503.

Six (6) cross tubes PASSED inspection.

THE MAINTENANCE DESCRIBED ABOVE HAS BEEN PERFORMED IN ACCORDANCE WITH  
THE APPLICABLE STANDARDS OF AIRWORTHINESS

INSPECTED BY:

S. FLEKNER

DATE August 1, 2007

INSPECTION  
STAMP(S) Not Required

### CUSTOMER INFORMATION

CUSTOMER Dart Aerospace

P.O. NUMBER

4266

ADDRESS:

CONTACT NAME:

LABOUR

@

\$

MATERIALS

@

TRAVEL EXPENSES

@

GST

HOTEL EXPENSES

@

PST

INVOICE NO.

TOTAL \$

WHITE COPY - INSPECTION FILE • YELLOW COPY - CUSTOMER • PINK COPY - ACCOUNTANT

Date: Friday, 5/25/2007 12:49:28 PM  
 User: Kim Johnston

## Process Sheet

26

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212/205 HIGH FED X-TUBE ASSEMBLY
Job Number	: 32674		
Estimate Number	: 10254		
P.O. Number	:	Part Number	: D212664101
This Issue	: 5/25/2007 S.O. No. :	Drawing Number	: D212-664-141 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 32673	Material	:
Written By	:	Due Date	: 6/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <u>Kim Johnston</u>		
Comment	: Est Rev:E 04-02-16 Reformat KJ/DS		
	: Est Rev:F 06-03-29 Remove Comments on Pick List JLM		
	: Est Rev:G 07-04-30 As per Rev C JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101CHG003

07.06.05 JS

2.0	D6005128	Crosstube material
-----	----------	--------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6005-128 Crosstube

Check OD = 2.750"; ID = 2.000"

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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Comment: MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs DT8534 on both ends as per Folio FA113

2-Turn first side as per Folio FA113

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141.

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

REFERENCE ONLY